

3
Work Order ID 127656

127656

Page 1

December-17-14 1:42:18 PM

Item ID: D4775-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Strut Assembly
Start Date: 12/17/14 Start Qty: 10.00 *10* Cust Item ID:
Required Date: 12/17/14 Req'd Qty: 10.00 *10* Customer:
Reference:

Approvals: Process Plan: MLS Date: 12-23 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4775	C

110	Pick Kit	0.00							
110	Large Fab								
Packaging									
Packaging	Memo	0.00							

10 FF JAN 15 2015

120		0.00							
120									
Small Fab									
Small Fab	Memo	0.00							

1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG

A/R PROSEAL BATCH: M130090

2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

10 FF JAN 15 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>10</u>			<u>38</u> 9-89 JAN 15 2015
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>SX514</u> Memo	0.00 0.00				<u>10</u>		<u>JAN 15 2015</u>	<u>045</u> <u>06</u> 9-89
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				<u>MLJ</u>	<u>15-01-16</u>		<u>MLF</u> <u>15-1-15</u>

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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D4775-041

Required Date: 12/17/14

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1		Manufactured	No			110	Each	4.0000	1	10			
D4775-1 Strut Tube													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST514	127707	4				10			
				126819		4							
D4777-1		Manufactured	No			110	Each	0.0000	1	10			
D4777-1 Rod End Bearing													
D4776-1		Manufactured	No			110	Each	4.0000	1	10			
D4776-1 Basket Strut Clevis													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST126	127802	4				10			
				121785		1							
				122550		3							
D4776-5		Manufactured	No			110	Each	0.0000	4	40			
D4776-5 Spacer													

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Picklist Print

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Work Order ID: 127656

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Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 12/17/14

Required Date: 12/17/14

Start Qty: 10.00

Required Qty: 10.00

AN3-10A

Purchased

No

110

Each

218.0000

2

20

AN3-10A

Bolt

FF

JAN 15 2015

Location

Loc Qty

Loc Code

GA

16

m127817

16

ST338a

200

m130466

200

20

ST349

2

m128813

2

MS21042L3

Purchased

No

110

Each

998.0000

2

20

MS21042L3

Nut

FF

JAN 15 2015

Location

Loc Qty

Loc Code

FP001

489

M130922

489

20

GA

33

M128754

33

ST305

473

M130799

473

ST307

3

123900

3

MS21209-F615

Purchased

No

110

Each

3.0000

1

10

MS21209-F615

Heli-Coil

FF

JAN 15 2015

Location

Loc Qty

Loc Code

GA

3

131270

m130325

3

10

DQA: _____ Date: _____



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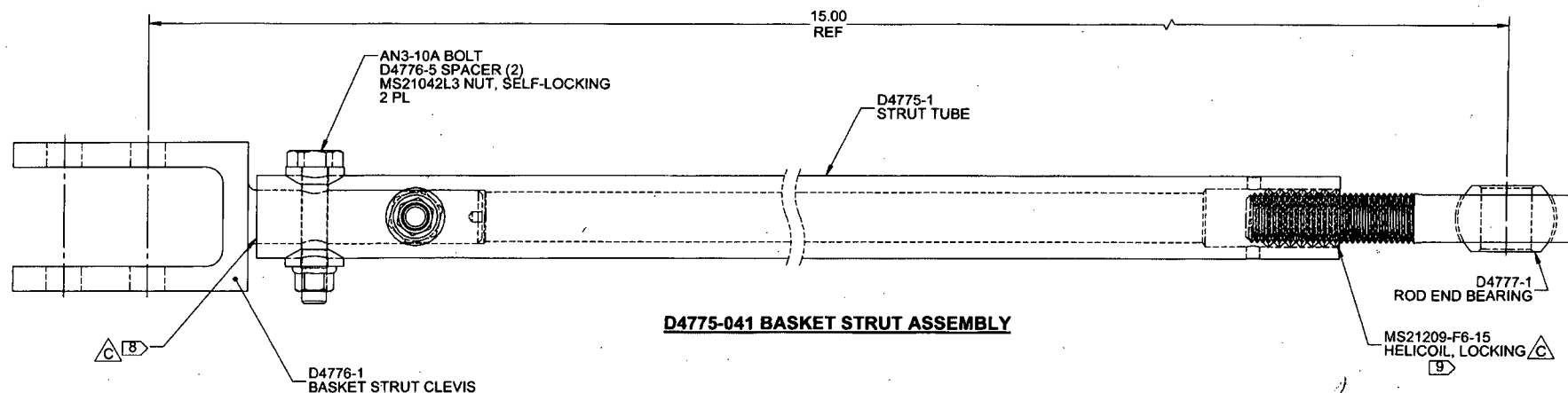
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4775-041	BASKET STRUT ASSEMBLY
1	1	D4775-1	STRUT TUBE
2	1	D4776-1	BASKET STRUT CLEVIS
3	4	D4776-5	SPACER
4	1	D4777-1	ROD END BEARING
5	2	AN3-10A	BOLT
6	2	MS21042L3	NUT, SELF-LOCKING
7	1	MS21209-F6-15	HELICOIL, LOCKING



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: PER QSI 044 6.1
 - 7) WEIGHT: 0.45 lbs
 - 8) APPLY PROSEAL 890 B-2 (PRC) TO THE STEM OF ITEM 2 TO PREVENT RATTLING.
 - 9) ENSURE HELICOIL DOES NOT BLOCK HOLE.

RELEASED
R 2014-01-07

C	ITEM 7 WAS F6-20, B2-2 Ø0.098 "WITNESS HOLE" ADDED. REASON: CUSTOMER FEEDBACK. ADDED NOTE 8. REASON: DESIGN IMPROVEMENT.	AJS	13.11.01
B	DELETED WELD PINS (-3) REPLACED WITH FASTENERS. REASON: PREVENT CRACKING & EASE OF MANUFACTURE. C6-2 HOLE PATTERN ON -1 REVERSED TO ENSURE FASTENERS CLEAR STRUCTURE. FINISH NOTE MOVED TO -1 (SHEET 2).	AJS	13.08.14
A	NEW ISSUE	AJS	13.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D4775	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET STRUT ASSEMBLY	NTS
DATE	13.11.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

